

Date: Wednesday, 03/09/2008 10:26:12 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE
Job Number	: 41725		
Estimate Number	: 12930		
P.O. Number	:	Part Number	: D29322UP
This Issue	: 03/09/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2932 REV C
First Issue	: / /	Project Number	: N/A
Previous Run	: 35227	Drawing Revision	: C
	Type : MACHINED PARTS	Material	:
Written By	:	Due Date	: 26/09/2008
Checked & Approved By	: <u>JLD 08.03</u>	Qty:	2 Um: Each
Comment	: Est Rev:A New Issue 07-07-04 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101003	Saddle Billet, 7075
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 7075-T7351 2X6.25X7.875
 Issue material from stock: 7075-T7351 (QQ-A-250/12)
 Cut Size 2.0 x 6.25 X 7.88
 Grain Along Long 7.88 Length
 Batch No: 34873

S.F 08/09/11

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Program part number and batch number.
 1-Inspect part number and batch number are programmed correctly.
 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet
 3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet
 4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet
 5-Deburr

S.F 08/09/11

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Machine Keyway and inspect per attached dimension sheet

S.F 08/09/11

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

S.F 08/09/11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 03/09/2008 10:26:12 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE

Job Number: 41725

Part Number: D29322UP

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 08/09/12

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M. 08/09/12

(2x)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FL 08/09/12 (2)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 444

6/9/12

(2x)

SD

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/15

Job Completion



MF 08-09-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 41725
Description: 206 Saddle, Outboard, Right side	Part Number: D2932-2
Inspection Dwg: D2932 Rev. C	Page 1 of 1

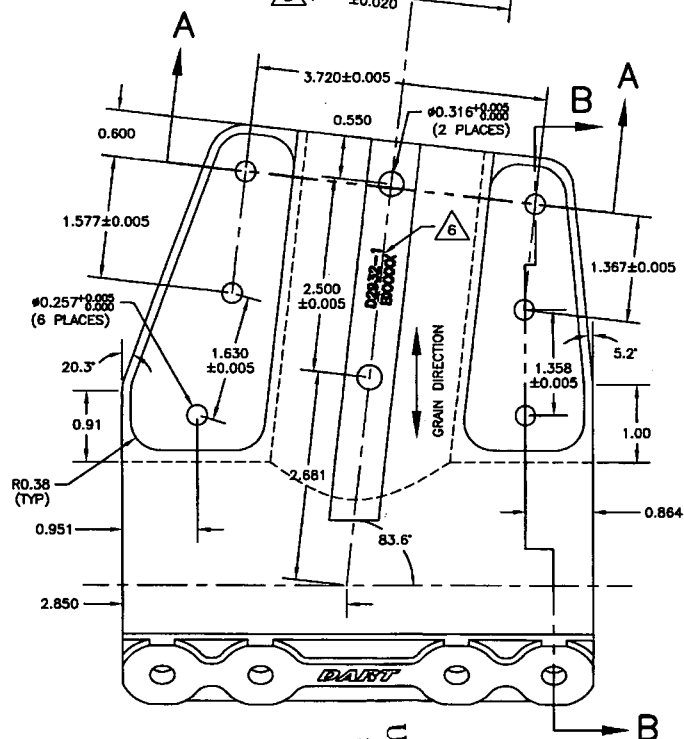
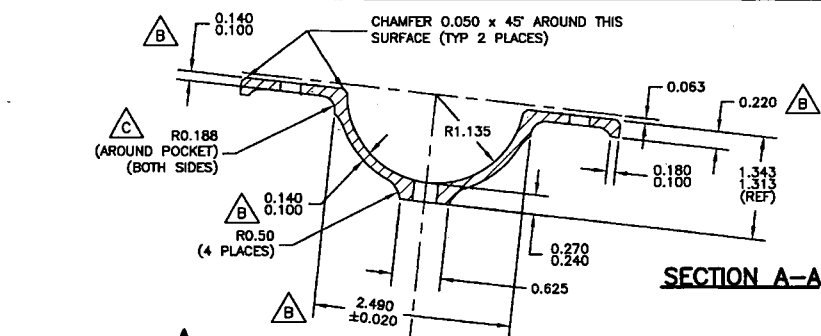
Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.130	.130				
B	0.100	0.140		.130	.130				
C	0.100	0.140		.127	.127				
D	0.210	0.230		.223	.223				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.510	.510				
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		.258	.258				
L	0.312	0.317		.314	.314				
M	0.235	0.240		.238	.238				
N	0.100	0.140		.110	.110				
O	0.540	0.560		.550	.550				
P	0.490	0.510		.500	.500				
Q	3.715	3.725		3.718	3.718				
R	2.470	2.510		2.490	2.490				
S	0.240	0.270		.250	.260				
T	0.100	0.180		.140	.140				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.370	1.370				
W	0.316	0.321		.321	.321				
X	1.125	1.145		1.131	1.131				
Y	1.565	1.585		1.570	1.570				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

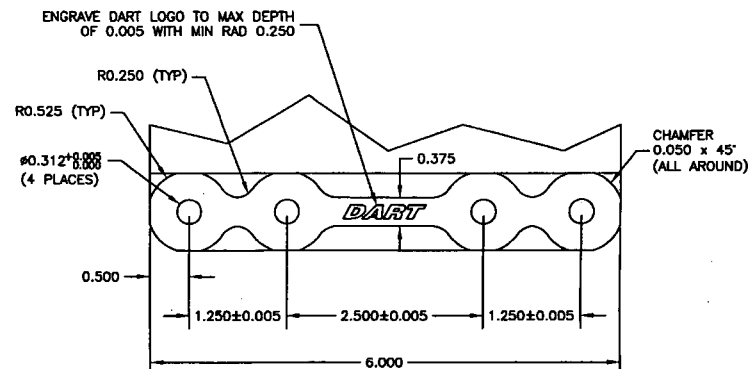
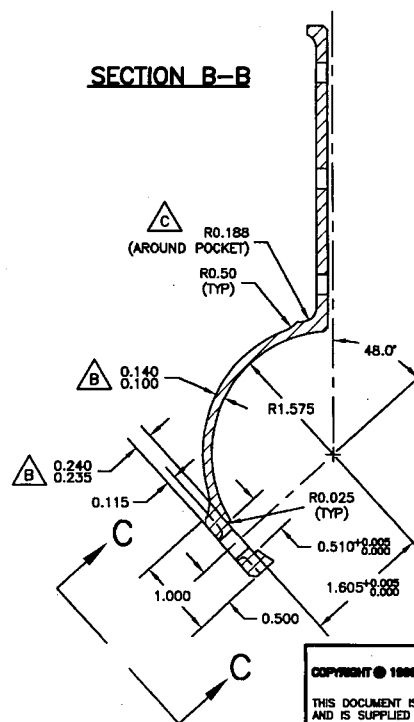
Measured by: <i>RF</i>
Date: 08/09/11

Audited by: J.L
Date: 08/09/12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>



SECTION B-B



VIEW C-C

D2932-1 LH SADDLE (SHOWN)
D2932-2 RH SADDLE (OPPOSITE)

- NOTES:**
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D8101-003 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO. D2932
DATE		TITLE SADDLE OUTSIDE
06.11.09		SCALE 2:3

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RELEASED

07-02-12

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 WORK ORDER
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 ENGINEERING
 RETURN TO
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